

# Work Order ID 74101

Wednesday, September 21, 2011 1:28:08 PM



Page 1

Item ID:	D4018-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Short Basket Lid Assembly (350 )					
Start Date:	9/21/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	9/30/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-09-21	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4018	C

100	Weld per dwg A/R S.S. rod Batch: <u>MH4649</u>	0.00
	Large Fab	
Large Fab	Memo	0.00
Large Fab	1- assemble ribs , weld as per dwg D4018 using DT9607B 2- weld hinge (3) and Mounting brackets as per dwg D4018 ***inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D4018 ***make sure to place mesh correctly on lid, check with label plate before tacking mesh***	
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
QC	Memo	0.00
Quality Control		

*EL / PMB 11/09/28*

*Cpt 11-29-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Revision ID:					Stop	
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Start Date:	9/21/2011	Start Qty:	1.00			
Required Date:	9/30/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

W115128

\*\*\* mask sides of hinge prior to powdercoat\*\*\*  
 Start Time: 9:00  
 Oven Temperature: 320°F  
 Finish Time: 9:30

140	Wing Walk as per dwg QSI005 4.4 Batch M11831300	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Install placard and label as per dwg

\*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label \*\*\*

IX Ø M-11/04/30

1 of 11/10/03

W/O:		WORK ORDER CHANGES					
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**Work Order ID 74101**

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Wednesday, September 21, 2011 1:28:08 PM

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350 )

Start Date: 9/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

0.00 *5.16/03*

QC

Memo

Quality Control

160

Identify as per dwg & Stock Location: W/O0.00 *D4032-041 / B7-1099*

0.00

Packaging

Memo

Packaging

*1 of 11/10/03*

170

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

*11/10/11*  
*mf*  
*11-10-06*

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Wednesday, September 21, 2011 1:28:13 PM

[illegible][illegible]**Required Date: 9/30/2011**

**Required Qty: 1.00**

**Comments:** IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1  Rib		Manufactured	No			100	Each	8.0000	2	2		11/09/28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				5					
					72545			5					
				WA005				3					
					73031			3		2			
D4018-3  Rib		Manufactured	No			100	Each	12.0000	2	2		11/09/28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
					72546			4		2			
				WA005				8					
					68479			2					
					73032			6					
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	31.0000	3	3		11/09/28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				30					
					72116			12		3			
					73630			18					
				WA005				1					
					71941			1					

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Page 2

Work Order ID: 74101

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5 Manufactured No

100 Each

29.0000

6



Rib



6  
EL/PMB 11/09/28

Location

Loc Qty

Loc Code

WA

29

70758

5

72544

6

73631

18

D4035-041 Manufactured No

100 Each

3.0000

1



Lid Rib Assembly, Fwd (350 Basket)



1  
EL/PMB 11/09/28

Location

Loc Qty

Loc Code

WA

3

63720

0

72657

3



D4035-043 Manufactured No

100 Each

8.0000

1



Lid Rib Assembly, Aft (350 Basket)



1  
EL/PMB 11/09/28

Location

Loc Qty

Loc Code

WA

2

72542

2

WA006

6

73628

6

Wednesday, September 21, 2011 1:28:13 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2581  
  
 Mounting Bracket

Manufactured No

100 Each

34.0000

2

2



*EL / PMB 11/09/28*

Location

Loc Qty

Loc Code

WA

34

69258

1

69739

2

70766

2

73079

29

D4020-7  
  
 Mesh (350 Basket Short, Lid)

Manufactured No

100 Each

1.0000

1

1



*EL / PMB 11/09/28*

Location

Loc Qty

Loc Code

WA

1

68523

1

D4021-3  
  
 Data Plate

Manufactured No

100 Each

11.0000

1

1



*EL / PMB 11/09/28*

Location

Loc Qty

Loc Code

WA

11

71943

5

73632

6

D2728-3  
  
 Dart Logo label

Manufactured No

140 Each

0.0000

1

1



*M15050 11/30/28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

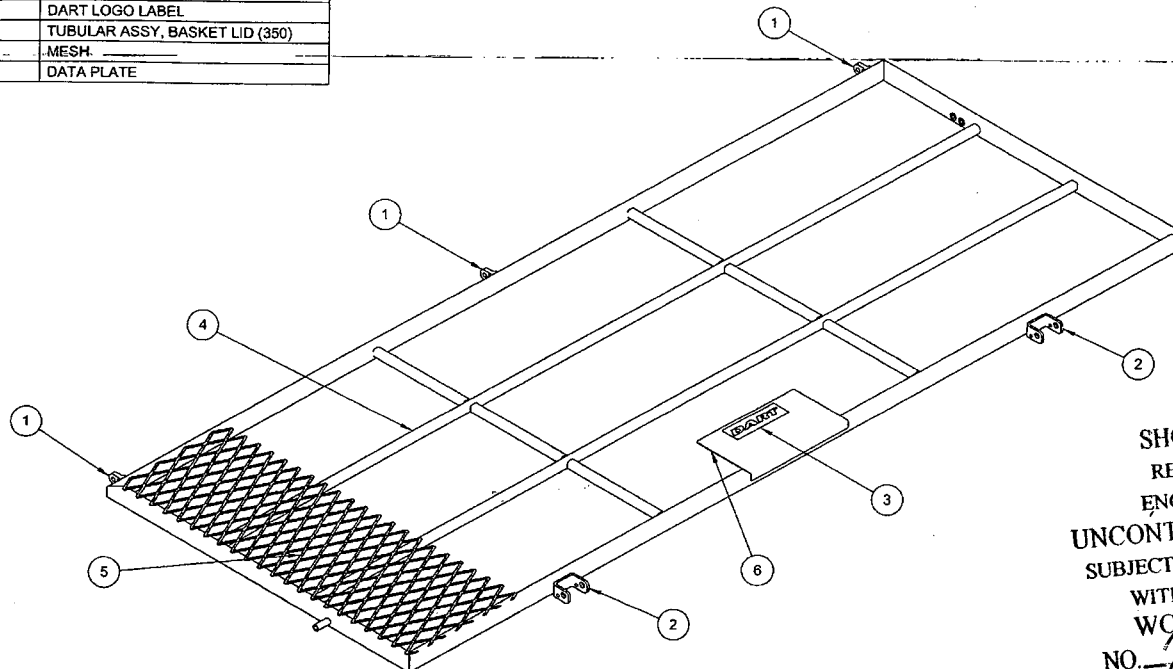
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**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74101-09-21

RELEASED  
10.08.05

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AKS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	AKS		
APPROVED	AKS		
DE APPR.	AKS		
DATE	10.08.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4018** REV. C  
SHEET 1 OF 4  
TITLE **SHORT BASKET LID ASSY (350)** SCALE NTS

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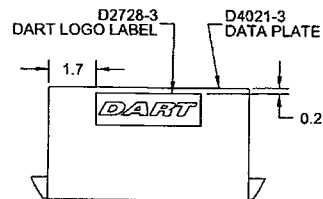
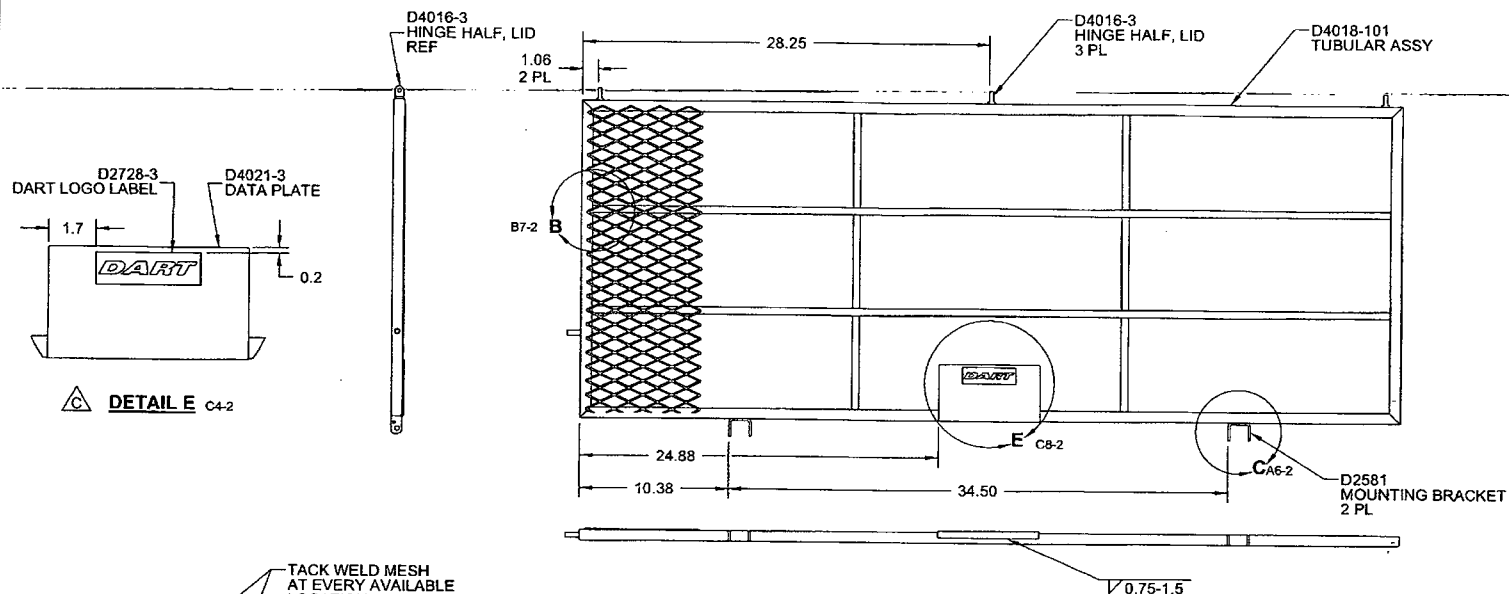
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

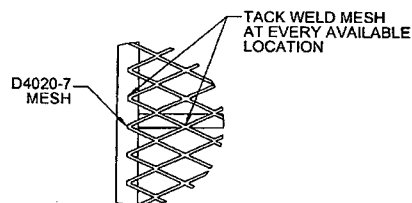
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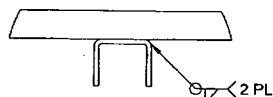
**NOTE:** Date & initial all entries



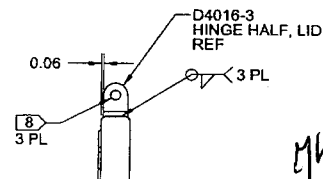
**DETAIL E** C4-2



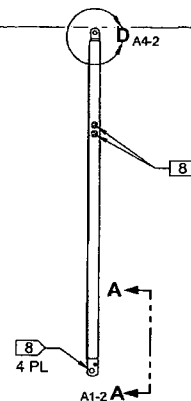
**DETAIL B** C8-2



**DETAIL C** C3-2



**DETAIL D** D1-2



**VIEW A-A** C1-2

**RELEASED**  
10.08.12

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 14.5 lbs APPROX
  - 8) MASK HOLES PRIOR TO FINISHING
  - 9) WELD PER DART QSI 004

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	<b>D4018</b>	SHEET 2 OF 4
APPROVED	ALS	TITLE	SCALE
DE APPR.	SC	<b>SHORT BASKET LID ASSY (350)</b>	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

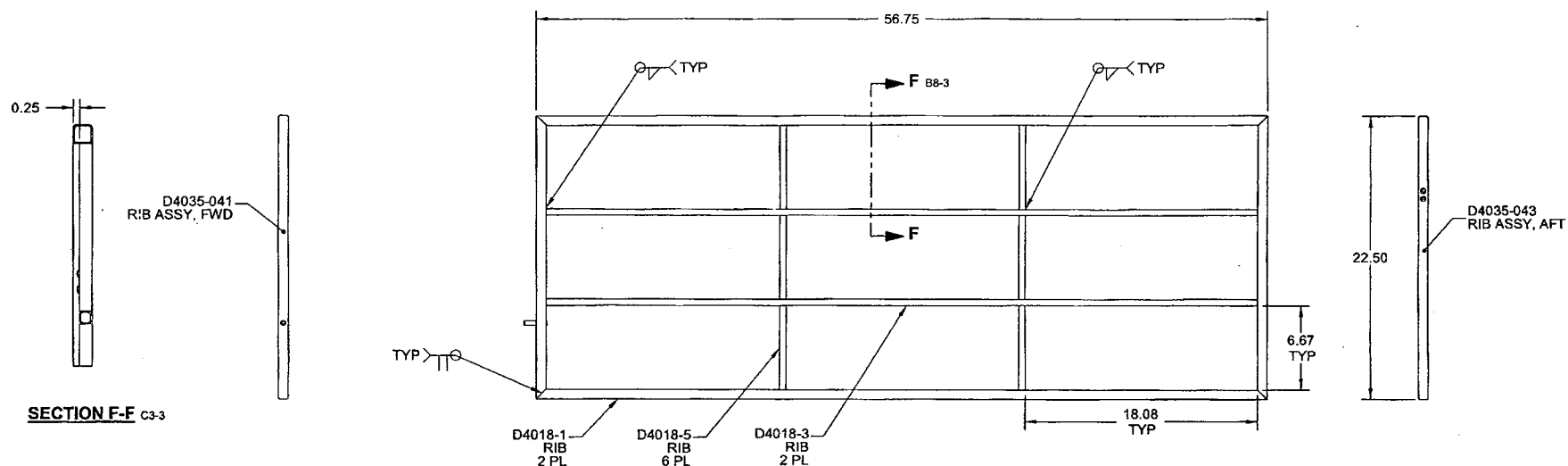
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**NOTE:** Date & initial all entries



ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED  
10.08.12 UP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D4018	REV. C
CHECKED	SC		SHEET 3 OF 4
MFG. APPR.	SC	TITLE SHORT BASKET LID ASSY (350)	SCALE NTS
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DE APPR.	SC		
DATE	10.08.05		

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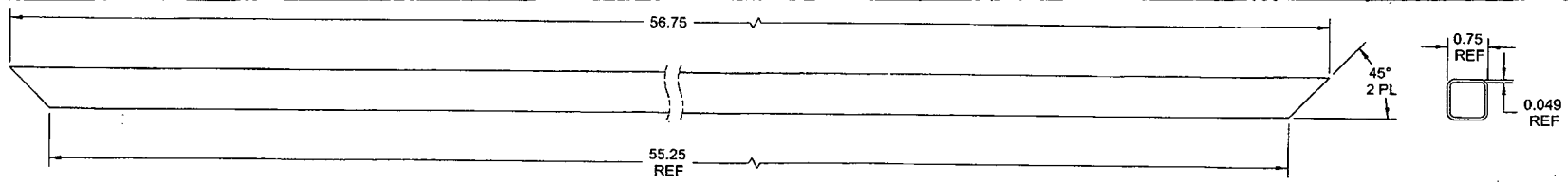
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8 7 6 5 4 3 2 1

D

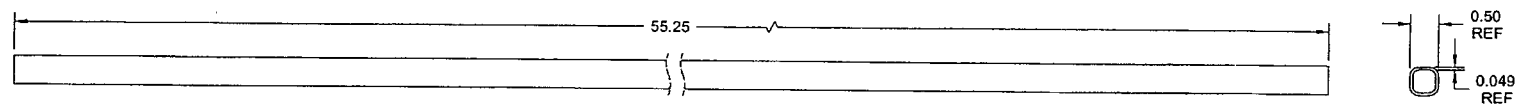
D



**D4018-1 RIB**

C

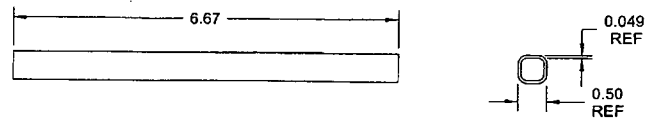
C



**D4018-3 RIB**

B

B



**D4018-5 RIB**

14161

RELEASED  
10-08-12

**NOTES:**

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	A15	<b>DART AEROSPACE LTD</b>	
DRAWN	ISC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO.	REV. C
MFG. APPR.	ISC	D4018	SHEET 4 OF 4
APPROVED	ISC	TITLE	SCALE
DE APPR.	ISC	SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

A

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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